

Work Order ID 77539

77539

Page 1

December-13-11 8:38:56 AM

Item ID: D350-588-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Door Fwd Hinge Modification

Start Date: 13/12/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 09/01/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: M.L.S

Date: 11/12/13

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-011 CHG002

5/12/13

for M.L.S 12-2-6
(10)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

12/2/6
(10)

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

5/12/13

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77539

77539

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December-13-11 8:38:56 AM

Item ID: D350-588-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Door Fwd Hinge Modification
 Start Date: 13/12/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 09/01/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-588-011								
	Location: <u>122</u>								
	PPP Rev: <u>C</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/2/11 10

12/2/8 20

ME
12-02-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 77539

77539

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 13/12/2011

Required Date: 09/01/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:M04.08.31Added D2690-17KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7

Purchased

No

120

Each

160.0000

2

20

**

AN526C1032R7

Screw

Location

Loc Qty

Loc Code

ST348

160

116304

8

119436

2

119449

150

AN526C832R8

Purchased

No

120

Each

127.0000

8

80

**

AN526C832R8

Screw

Location

Loc Qty

Loc Code

ST347

127

118926

27

119798

100

AN526C832R9

Purchased

No

120

Each

432.0000

8

80

**

AN526C832R9

Screw

Location

Loc Qty

Loc Code

ST347

432

118983

350

119756

82

AN960JD10

NAS1149D0363J

Purchased

No

120

Each

0.0000

4

40

**

AN960JD10

Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 77539

77539

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 13/12/2011

Required Date: 09/01/2012

Start Qty: 10.00

Required Qty: 10.00

AN960JD8 NAS1149DN832 Purchased No

120 Each 0.0000 [24 240

S *HO* *AN960JD8*

Washer

**

11/17/12

sf

D2143 Manufactured No

120 Each 36.0000 [1 10

S *D2143*

Hinge Bracket

**

sf

Location

Loc Qty

Loc Code

ST -2

76100 36

ST198 38

10

D2144 Manufactured No

120 Each 11.0000 1 10

S *D2144*

Hinge Bracket

**

sf

Location

Loc Qty

Loc Code

ST198 11

73553 11

10

D2150 Manufactured No

120 Each 42.0000 2 20

S *D2150*

Packer Doubler, Hinge

**

sf

Location

Loc Qty

Loc Code

ST006 42

76953 42

20

D2151 Manufactured No

120 Each 18.0000 2 20

S *D2151*

Packer Doubler, Hinge

**

2x
B76013

12/2/10

Location

Loc Qty

Loc Code

ST006 18

76988 18

18

December-13-11 8:38:59 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 77539

77539

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 13/12/2011

Required Date: 09/01/2012

Start Qty: 10.00

Required Qty: 10.00

D2153 Manufactured No

120 Each 24.0000

**

D2153

Door Prop

Location

Loc Qty

Loc Code

ST272

24

76056

24

Manufactured No

120 Each

2.0000

**

D2154

D2154

Stud Bracket

Location

Loc Qty

Loc Code

ST006

2

64312

2

Manufactured No

120 Each

2.0000

**

D2237

D2237

Striker Plate

Location

Loc Qty

Loc Code

ST009

2

66139

2

Manufactured No

120 f

410.8037

**

D2461

D2461

Neoprene "D" Seal

Location

Loc Qty

Loc Code

ST402

410.8037

39782

6.5

55054

4

63880

7.6237

73644

392.68

7.25

76.31579

cut 1 X 87.00"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 77539

77539

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 13/12/2011

Required Date: 09/01/2012

Start Qty: 10.00

Required Qty: 10.00

D2463 Manufactured No

120 f

293.6838 7.25 76.31579

D2463

Seal

**

12/2/6 SP

Location

Loc Qty

Loc Code

ST404

293.6838

64944

1.71

66954

0.1088

72232

291.865

D2583 Manufactured No

120 Each

21.0000

D2583

Latch Bracket

**

20 B78402 SP

Location

Loc Qty

Loc Code

ST017

21

76074

21

D2585 Manufactured No

120 Each

29.0000

D2585

Mounting Channel

**

20 B77696 SP

Location

Loc Qty

Loc Code

ST017

29

73297

2

74488

27

D2586 Manufactured No

120 Each

31.0000

D2586

Door Latch

**

20 B77687 SP

Location

Loc Qty

Loc Code

ST204

31

74489

31

11x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 77539

77539

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 13/12/2011

Required Date: 09/01/2012

Start Qty: 10.00

Required Qty: 10.00

D2587

Manufactured No

120 Each 16.0000

**

10

D2587

Door Slug, 350 Hinge

Location

Loc Qty

Loc Code

ST017

16

74522

16

120 Each 40.0000

**

10

D2589

Manufactured No

D2589

Keys, Key Chain, 350 Hinge

Location

Loc Qty

Loc Code

ST018

40

58194

40

120 Each 16.0000

**

10

D2690-17

Manufactured No

D2690-17

Cable

Location

Loc Qty

Loc Code

ST020

16

66510

1

76139

15

120 Each 33.0000

**

10

D2857-1

Manufactured No

D2857-1

Hinge Bracket

Location

Loc Qty

Loc Code

ST024

33

69932

9

75253

24

8

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 77539

77539

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 13/12/2011

Required Date: 09/01/2012

Start Qty: 10.00

Required Qty: 10.00

D2857-2

Manufactured No

120 Each 28.0000

1 10

**

SP

S
740
D2857-2
Hinge Bracket

Location

Loc Qty

Loc Code

ST024

28

67001

4

75252

24

4
6

D2858-1

Manufactured No

120 Each 18.0000

1 10

**

SP

S
740
D2858-1
Hinge Bracket

Location

Loc Qty

Loc Code

ST024

18

75250

18

10

D2858-2

Manufactured No

120 Each 14.0000

1 10

**

12/2/10 SP 90

S
740
D2858-2
Hinge Bracket

Location

Loc Qty

Loc Code

ST024

14

75251

14

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 77539

77539

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 13/12/2011

Required Date: 09/01/2012

Start Qty: 10.00

Required Qty: 10.00

FG-778150-550-ROL

Purchased

No

120

sf

3,592.231

1

10

***EG-778150-550-ROL ***

7781 9oz Glass 50"x125yd

**

Location

Loc Qty

Loc Code

CA

2616.231

117602

866.231

119099

1750

ST403

976

104845

3

108932

18

111166

392

113905

563

1- cut 1 square ft of glass cloth

MS20426AD3-4

Purchased

No

120

Each

4,484.000

12

120

MS20426AD3-4

RIVET

**

Location

Loc Qty

Loc Code

ST316

4484

104374

1100

110398

3384

MS20470AD4-5

Purchased

No

120

Each

2,046.000

18

180

MS20470AD4-5

Rivet, Universal Head

**

Location

Loc Qty

Loc Code

ST319

2046

118405

2046

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 77539

77539

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 13/12/2011

Required Date: 09/01/2012

Start Qty: 10.00

Required Qty: 10.00

MS21042L08

Purchased

No

120

Each

71.0000

18

180

MS210421 08

Nut

**

M120308

M120142

M120071

sl

Location

Loc Qty

Loc Code

ST300

2

119758

2

ST301

69

119901

69

MS21042L3

Purchased

No

120

Each

7,109.000

4

40

MS210421 3

Nut

**

sl

Location

Loc Qty

Loc Code

ST300

7109

117441

16

117885

32

118451

5

118927

3

119017

5994

119075

1059

40

MS27039-08-11

Purchased

No

120

Each

83.0000

2

20

MS27039-08-11

Screw

**

12/20/11

Location

Loc Qty

Loc Code

ST290

83

117441

83

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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December-13-11 8:39:00 AM

Work Order ID: 77539

77539

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 13/12/2011

Required Date: 09/01/2012

Start Qty: 10.00

Required Qty: 10.00

MS27039-1-15

Purchased

No

120

Each

122.0000

2

20

**

nh/650 (10)

MS27039-1-15

Screw

Location

Loc Qty

Loc Code

ST291

122

118093

22

119736

100

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1	1	D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT, (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00